

Date: Tuesday, 11/12/2007 1:47:42 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 36251		
Estimate Number	: 10368		
P.O. Number	: <u>N/A</u>	Part Number	: D30481
This Issue	: 11/12/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D3048 REV. A2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: A2
Previous Run	: 30519	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 12/12/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	2 Um: Each
Comment	: Est: A 02.11.19 New issue KJ/RF : Est Rev.B Now on Waterjet 06-10-15 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 3.6312 sf(s)/Unit Total : 7.2624 sf(s)  
 2024-T3 .063 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.063 thick  
 (M2024T3S.063) Batch: 106223 HB 07-12-11

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3048  
 Dwg Rev: A2  
 Prog Rev: A2

HB 07-12-11

(2)

2-Deburr if necessary

HB 07-12-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-12-11

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

HB 07/12/12 (42)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE  
 Form on CNC Brake per Dwg D3048

HB 07/12/18

(2)

Date: Tuesday, 11/12/2007 1:47:42 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36251

Part Number: D30481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*FeL 07/12/18 (2)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*6 7/12/18 (2)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57151

*one in GA ml 07/12/18 (1)  
one in store*

*6 7/12/19 (1)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



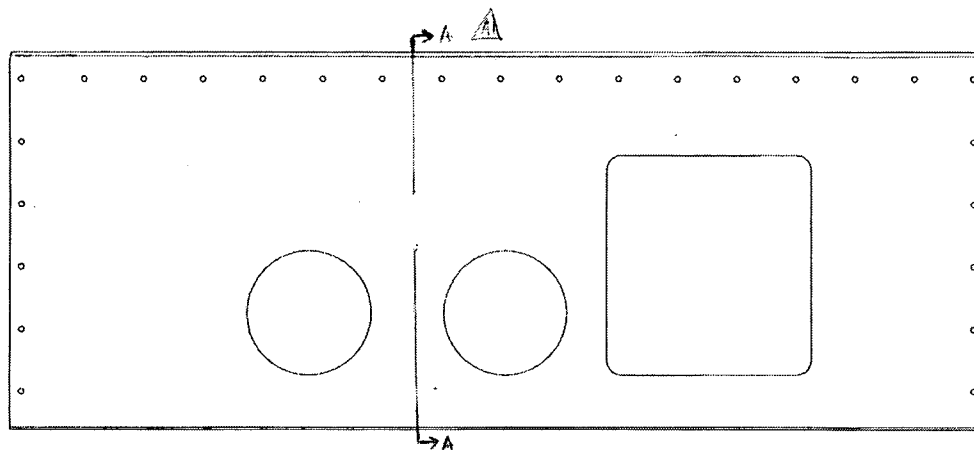
Comment: FINAL INSPECTION/W/O RELEASE

*(2)  
207/12/20*

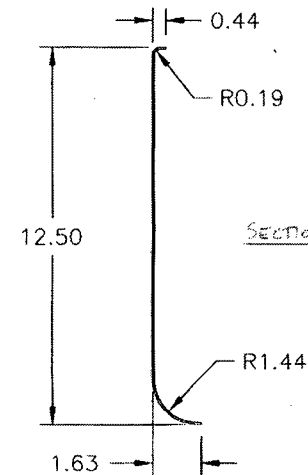
Job Completion



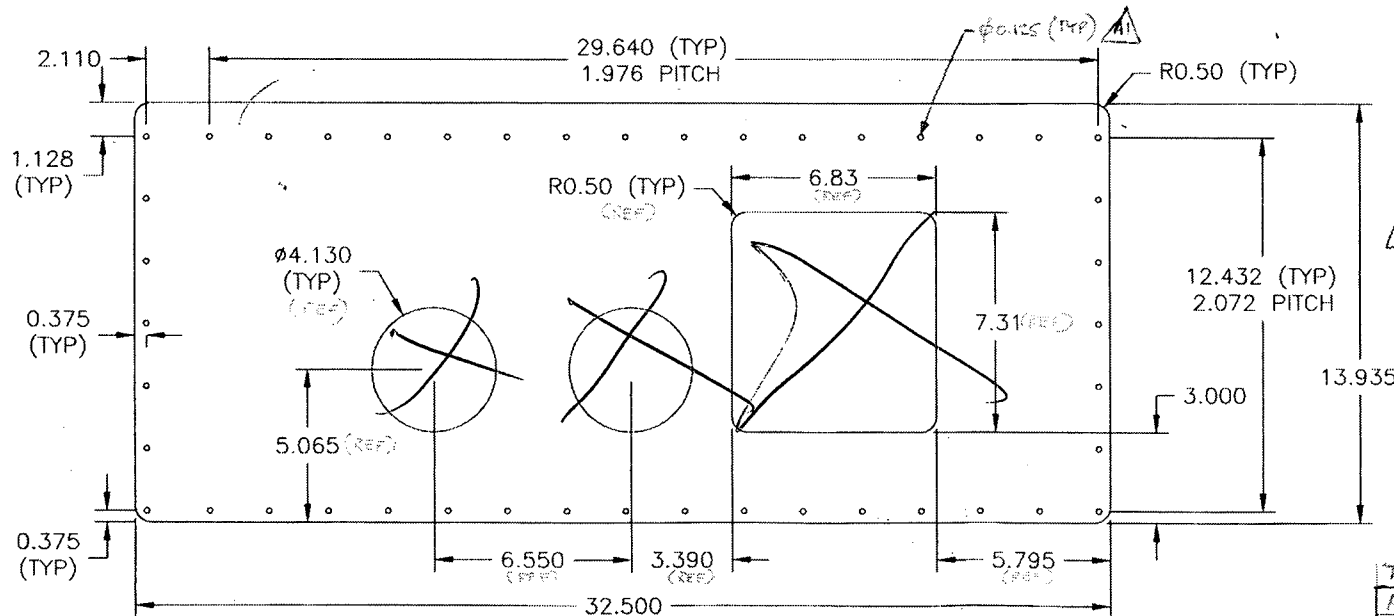
*in 2007/12/20  
W*



D3048-1



SECTION A-A



MATERIAL: 2024-T3 (QQ-A-250/4)  
0.063 THICK  
FINISH: ACID ETCH, ALODINE PER DART  
QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

△ ALL DIMENSIONS (TYPICAL) ARE GIVEN FOR REFERENCE ONLY, DO NOT CUT.

D3048-1 FLAT PATTERN

RELEASED  
01.04.27

COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

REV	01	02.11.20	CORRECT DWT ERROR
A	01.09.25	NEW ISSUE	
DESIGN	DART	DRAWN BY	RF
CHECKED		APPROVED	
DATE	01.09.25	TITLE	DOUBLER
DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA			REV. A SHEET 1 OF 1 SCALE 1:4

